

Date: Tuesday, 4/17/2007 3:50:21 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : X-TUBE AS 350/355 HI FWD ~~UNDER REVIEW~~
 Job Number : 31903A
 Estimate Number : 12484
 P.O. Number :
 This Issue : 4/17/2007 S.O. No. :
 Previous Rev. : NC
 First Issue : 11 Type : LANDING GEAR
 Previous Run : 31902A
 Part Number : D350748141
 Drawing Number : D350-748-141 ~~WR~~
 Project Number : N/A
 Drawing Revision : ~~ED~~ OK 402.04.18
 Material :
 Due Date : 5/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 402.04.18
 Comment : Est Rev: A New Issue 06-07-05 JLM
 Est Rev: B Update cadplate process 06-09-12 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

S.F. 07/04/22

2.0

D6017115

Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: 27471

S.F. 07/04/22

3.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

S.F. 07/04/22

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

S.F. 07/04/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31903A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA648

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

3-Scribe Part & Batch as per Dwg D350-748-141

SB 07/04/22

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SB 07/04/22

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MB 07/04/23

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

JP 7-4-25

9.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3777

C207105/15①

Heat Treat to min 180 KSI As per Dwg D350-748-141

(MIL-T-6736 OR AMS 2759-1C)

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

CP 07/06/04 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31903A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



PTO

Comment: DIMENSIONAL CHECK

close this w/o

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT _____

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: _____

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

OUTSIDE SERV.10

OUTSIDE SERVICES-LG



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: _____

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

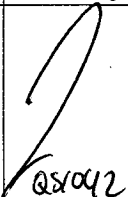
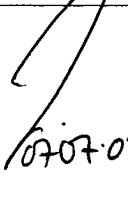
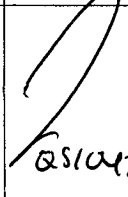

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-07-09	11.0	Tubes are unable to be identified.	 QS1042	See NCR 185 and w/o 33465	N/A	 07-07-09	 QS1042	 07-07-09

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31903A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

20.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: _____

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: _____

23.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 31903A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
Batch: _____

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Clamp (per MIL-DTL-8783C)
Batch: _____

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Screw
Batch: _____

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-748-241
Location: _____
PPP Rev: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31903A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. J. Johnston

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31903A
Description: Crosstube Assembly (AS350/355 High Fwd)	Part Number:	D350-748-141
Inspection Dwg: D350-748-141 Rev: <i>ED</i>		Page 1 of 1

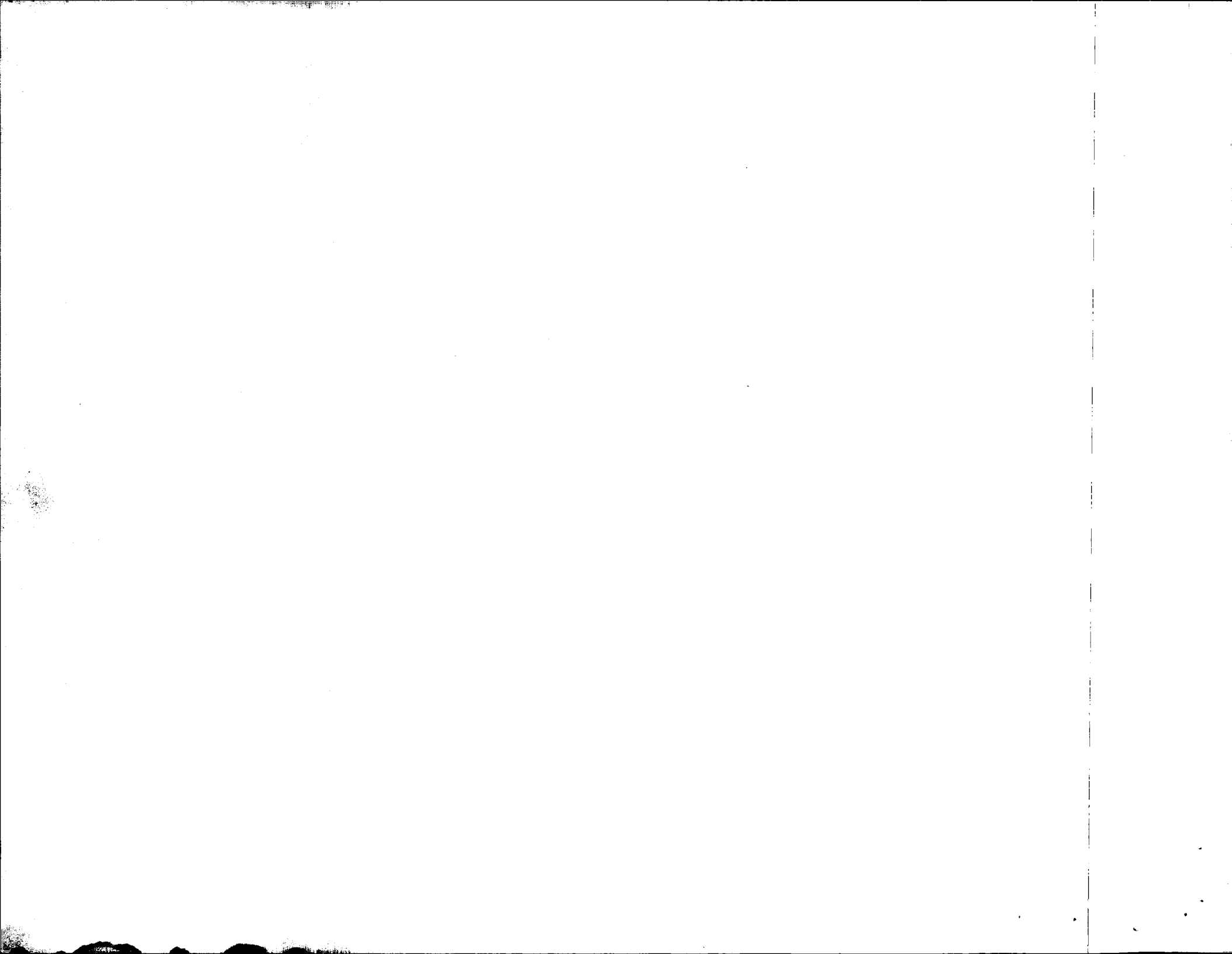
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	/		
	2.180	+0.005/-0.000	2.182	/		
	2.180	+0.005/-0.000	2.182	/		
	2.237	+0.005/-0.000	2.239	/		
	2.272	+0.005/-0.000	2.274	/		
	2.306	+0.005/-0.000	2.308	/		
	2.339	+0.005/-0.000	2.341	/		
	2.339	+0.005/-0.000	2.341	/		
	0.062	+/-0.010	.062	/		
	4.26	+/-0.030	4.260	/		
	R0.063	+/-0.010	.063	/		
	R0.50	+/-0.030	.500	/		
SIDE B	2.240	+0.005/-0.000	2.242	/		
	2.180	+0.005/-0.000	2.182	/		
	2.180	+0.005/-0.000	2.182	/		
	2.237	+0.005/-0.000	2.239	/		
	2.272	+0.005/-0.000	2.274	/		
	2.306	+0.005/-0.000	2.308	/		
	2.339	+0.005/-0.000	2.341	/		
	2.339	+0.005/-0.000	2.341	/		
	0.062	+/-0.010	.062	/		
	4.26	+/-0.030	4.260	/		
	R0.063	+/-0.010	.063	/		
	R0.50	+/-0.030	.500	/		
	110.27	+/-0.060	110.27	/		

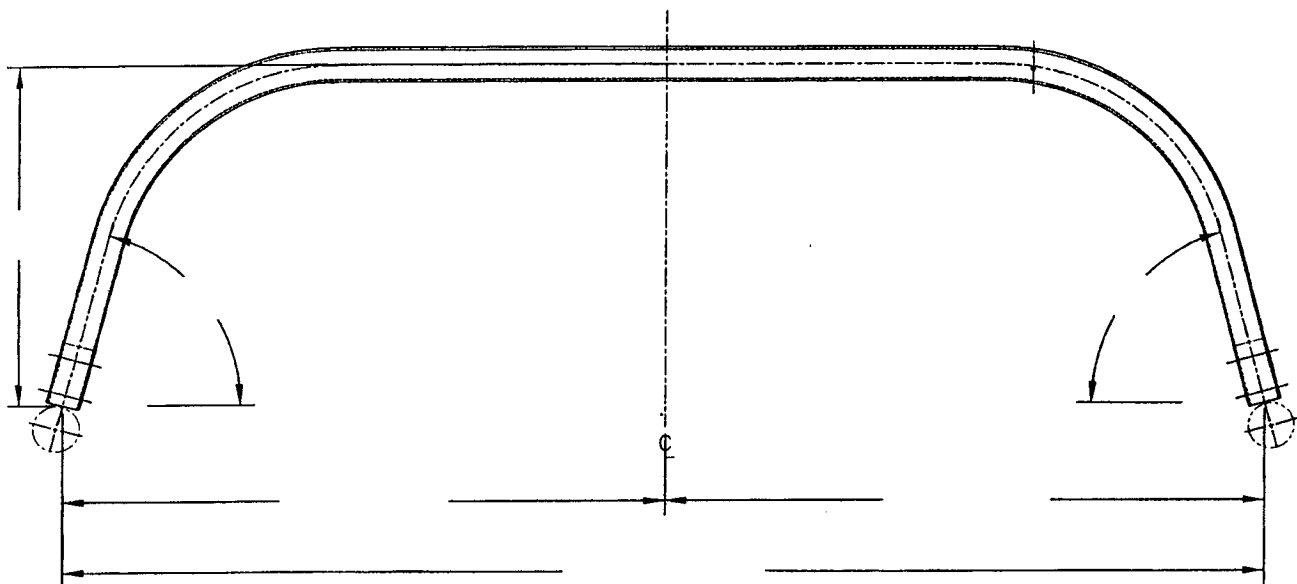
Measured by: <i>JS</i>	Audited by: <i>MS</i>	Prototype Approval:	N/A
Date: 07/04/22	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM <i>JS</i>	<i>BE</i>



DART AEROSPACE LTD		Work Order:	31903A
Description: Crosstube High Fwd (AS350/355)		Part Number:	D350-748-101
Inspection Dwg: D350-748-141 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**06.10.31 *[Signature]*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD) NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

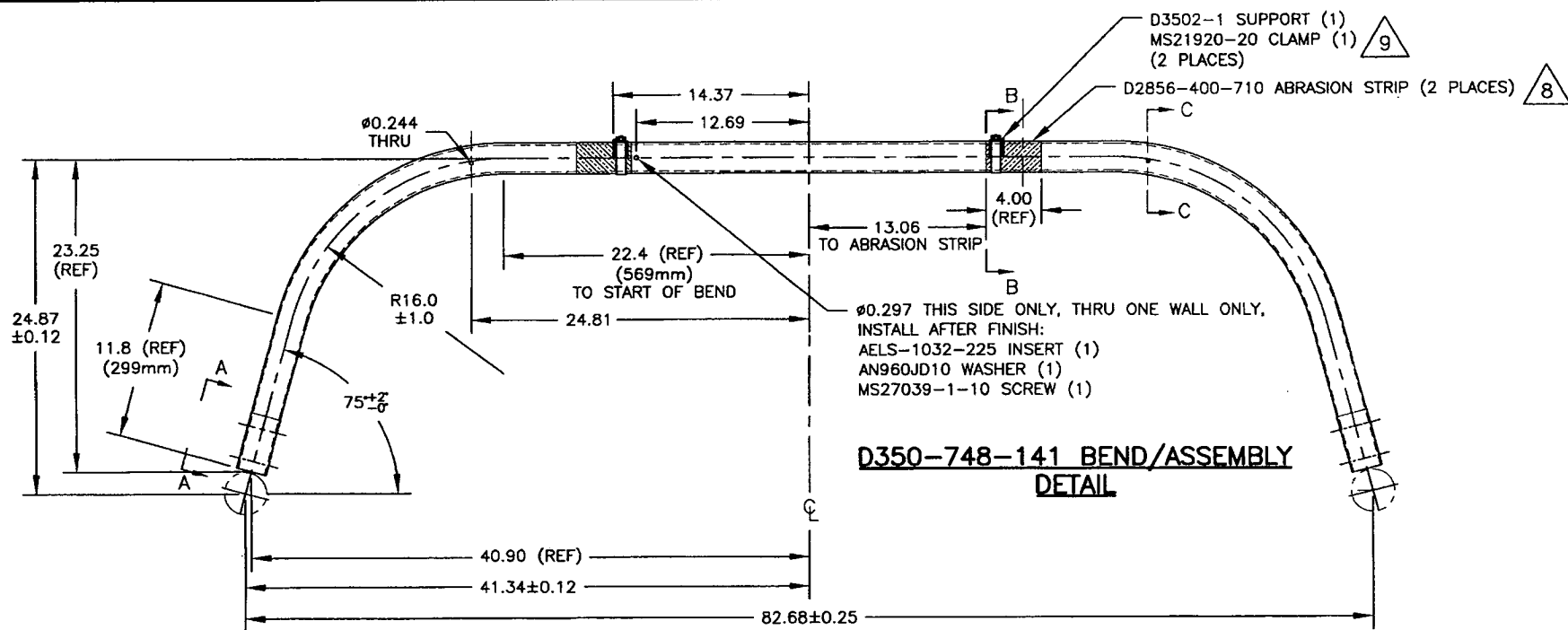
D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125
FINISHED LENGTH = 110.27 ± 0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING.
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR $\varnothing 0.297$ HOLE.

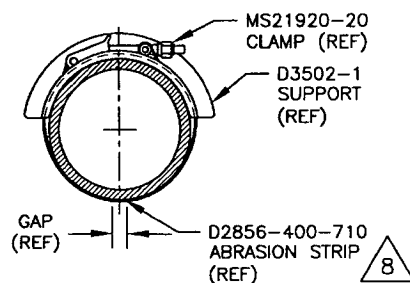
UNDER REVIEW07.02.16 *[Signature]*
CUTTING REDUCEDOK *[Signature]* 07.03.07

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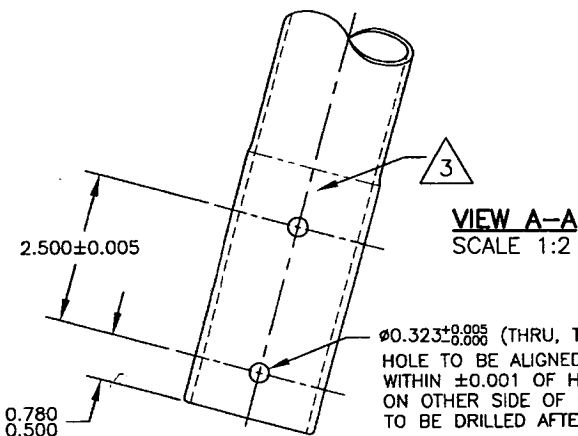
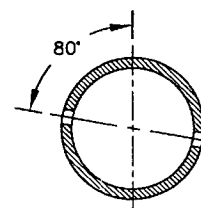
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SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



OK 07.07.07
UNDER REVIEW
07.07.16

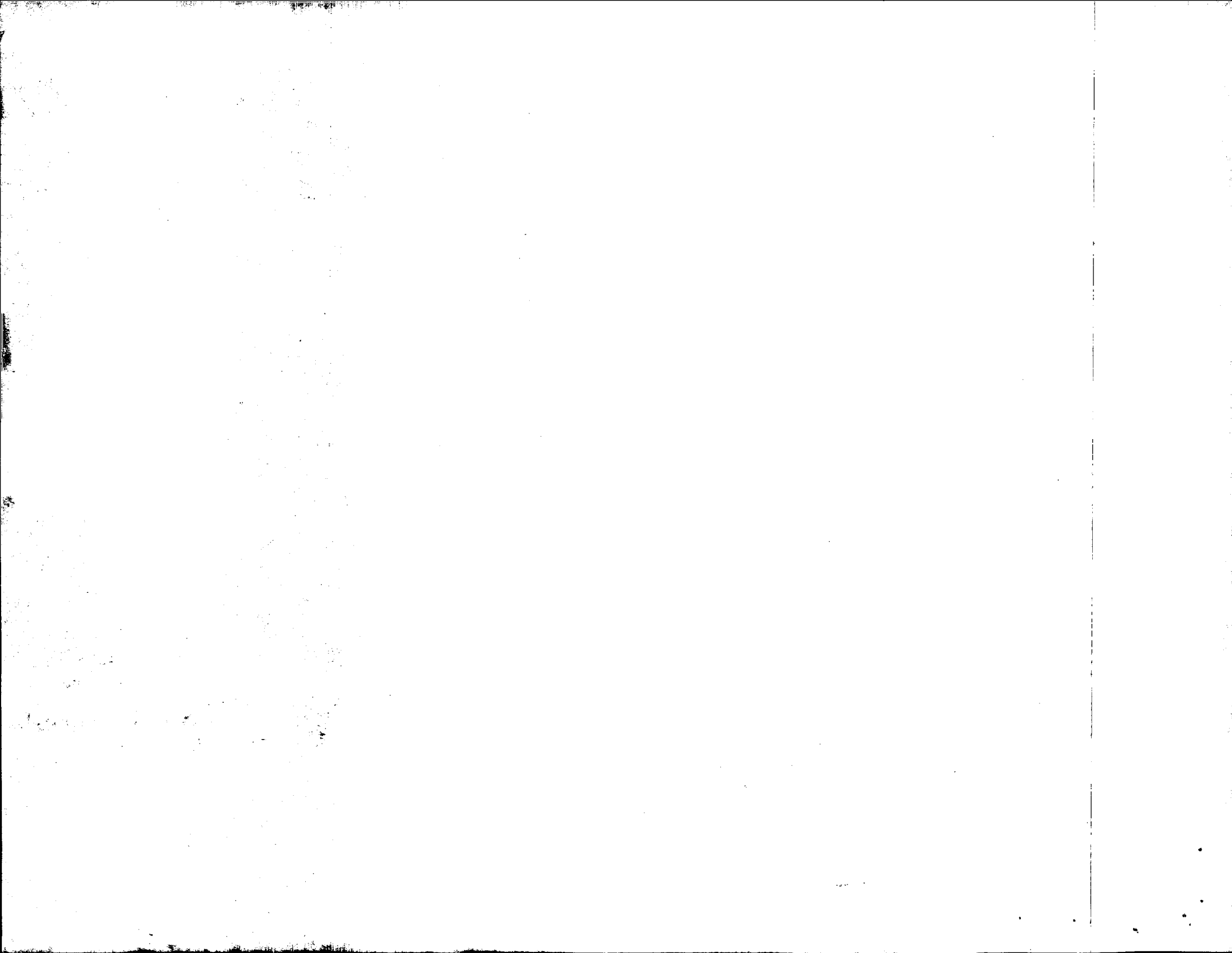
RELEASED
06.10.31

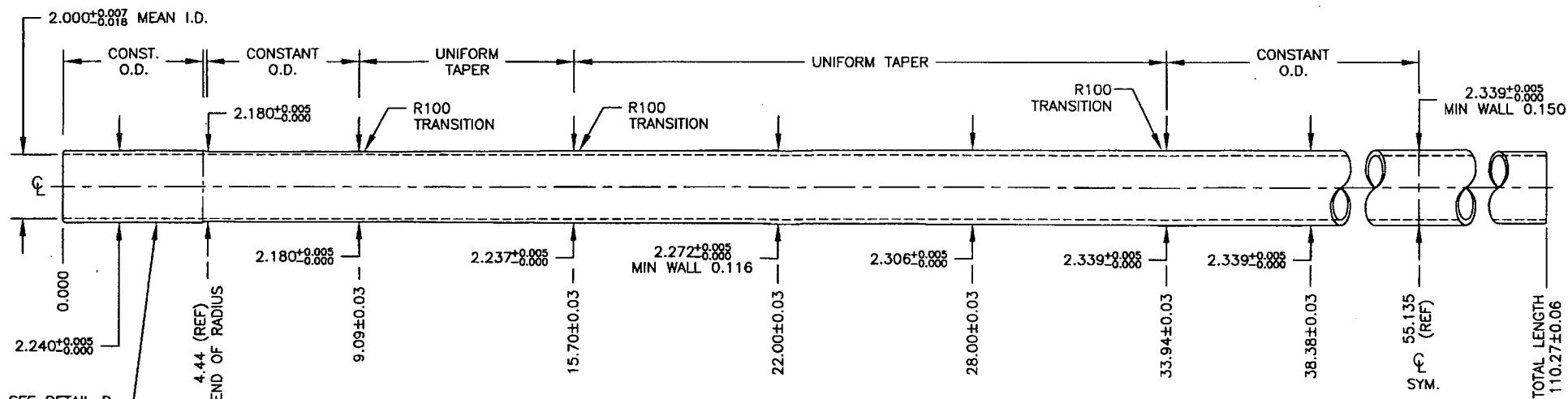
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DESIGN 90	DRAWN BY 90	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-141	REV. D SHEET 2 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:8

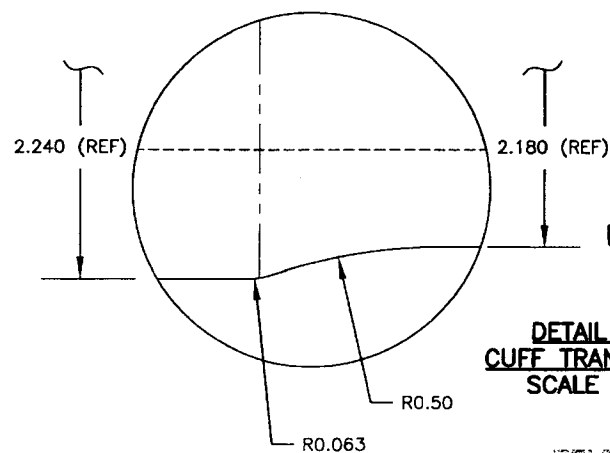
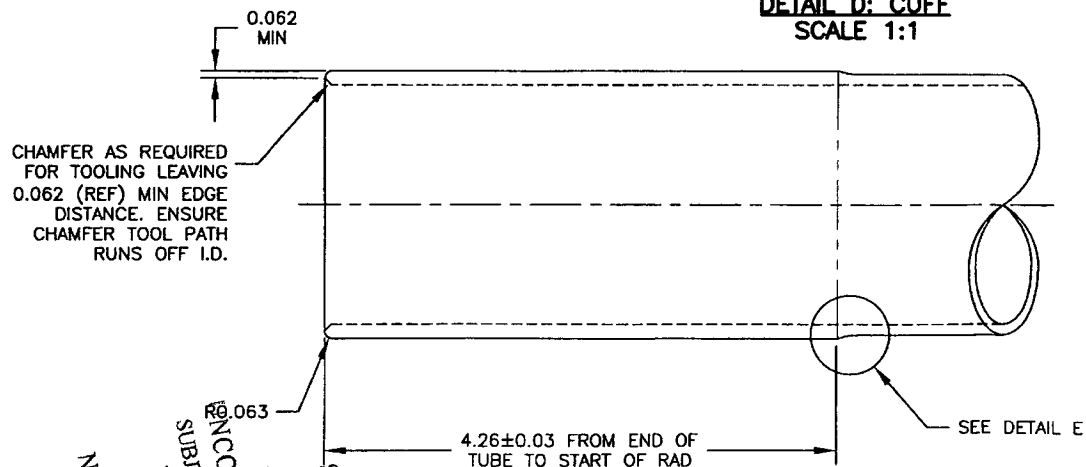
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
31903A





D350-748-141 MACHINING DETAIL

DETAIL D: CUFF SCALE 1:1



DETAIL E: CUFF TRANSITION SCALE 9:1

RELEASED

06.10.31

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DESIGN 40	DRAWN BY 40	DART	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED #	APPROVED #	DRAWING NO. D350-748-141	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE 1:3	

NO. 31903 A
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
CONTROLLED COPY
RETURN TO
SHOP COPY

AC AERO

INTERNATIONAL INC.

RELEASE NOTE

GST No.: R105468102

OAK 87500-1

05/29/2007

MM/DD/YYYY

PAGE: 1

2009 WYECROFT ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
(905) 827-4171 FAX: (905) 827-7489

2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
CANADA L6L 6J4
TEL: (905) 827-7377 FAX: (905) 827-1380

QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

TO: 1DAR01
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

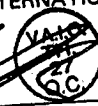
DATE SHIPPED	SHIP VIA	F.O.B.
05/29/2007	EPIC 4300450343	ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
3777		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141, 241 Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS CHECKED AS PER ASTM E-18 HRC 40-43 MATERIAL: 4130 SAND BLASTED P/S# 59141 6 PIECES P/N D350-748-141, S/N B31901A, B31902A, B31903A, B31904A, B31905A, B31906A 4 PIECES P/N D350-748-241, S/N B31907A, B31908A, B31909A, B31910A NOTE: NO SERIAL NUMBERS FOUND ON PARTS	EA	10	10	<div data-bbox="883 1043 1435 1266" data-label="Text"><p>100% HARDNESS TESTED 10 pcs → 42/43 HRC</p></div> <div data-bbox="1393 1226 1555 1352" data-label="Image"></div>

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



HEAT TREATING



SPECIAL PROCESSING FURNACE EQUIPMENT

Wednesday, 7/11/2007 10:42:33 AM
Jason Murdoch

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
Job Number : 33465 "C"
Estimate Number : 10804
P.O. Number : N/A
This Issue : 7/11/2007 S.O. No. : N/A
Print Rev. : NC
First Issue : N/A Type : LANDING GEAR
Previous Run : 00015

Drawing Name : D350-748-141

Part Number : D350748141
Drawing Number : D350748141 NCR185
Project Number : N/A
Drawing Revision : D OK
Material : N/A
Due Date : 8/5/2007

Split B
(P10) →

Written By :
Checked & Approved By :
Comment :

Qty: 1 Unit: Each

Additional Product

Job Number



Seq. #: Machine Or Operation: Description :

1.0 D350748141 CROSSTUBE ASSY HIGH FWD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

CROSSTUBE ASSY HIGH FWD

Pull D350-748-141 work orders B31902; B31903; B31904; B31905; B31906' from sequence 10.0. Continue as follows. Per NCR 185

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Identify the D350-748-141 with the part number, and current batch number, in alphabetical sequence. ie: B33465-A; B33465-B.....

EL 7-7-115

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7-07-11 (5)

4.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

5.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7-07-12 (5)

(P10) →
3rd Page